

Work Order ID 124976

Tuesday, September 30, 2014 1:28:45 PM

124976

Page 1

Item ID: D4635-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Ceiling Panel, LH
 Start Date: 9/30/2014 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/10/2014 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 10-9-30 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4635	E

100
100
 Thermoform
 Thermoforming Machine
 HAND FINISHING THERMOFORMING
 Memo
 Cut Blanks
 0.00
 0.00

DAS
 27
 9-89
 14/10/2

105
105
 HandThermo
 Hand Finishing Thermoforming
 Dry Material
 Memo
 Dry Sheet as per QSI022 POLYCARBONATE
 0.00
 0.00

Temp: 245 deg. F
 Time IN: 5:00 PM
 Time OUT: 6:00 AM

OCT 01 2014
 Per.....

DAS
 27
 9-89
 14/10/2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Tuesday, September 30, 2014 1:28:45 PM

124976

Page 2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Fwd Ceiling Panel, LH

Stop *NS2*

Start Date: 9/30/2014 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 10/10/2014 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

110

THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D4635-1 and Folio FTA147

Dwg. Rev. E

Folio Rev. 10

NOTE: Check moulds prior to using to ensure proper placement of add-ons.

Visually inspect for proper formation and texture

DAS

27

9-89

14/10/20

130

0.00

130

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

1 ~~B~~ 14/10/20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ </td> <td style="width: 33%;"> Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ </td> <td style="width: 33%;"> Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ </td> <td style="width: 33%;"> Engineering ☐ Quality ☐ Other ☐ </td> </tr> </table>	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* QC Quality Control	QC6- Inspect dimensions to drawing Dimensional Inspection Memo Fill out Inspection Sheet Rev A	0.00 0.00				<i>Shp</i> <i>14/11/12</i>			
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>B</i>			<i>15/04/29</i>
160 *160* Packaging Packaging	Packaging Memo	0.00 0.00							<i>B</i> <i>15/05/09</i>

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Equip/Tooling									
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Transport									
Unapproved									

FAULT CATEGORY

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Work Order ID 124976***124976***

Page 4

Item ID: D4635-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Fwd Ceiling Panel, LH

Stop ***NS2***

Start Date: 9/30/2014 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/10/2014 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MCS

MAY 05 2015

MCS

MAY 05 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Tuesday, September 30, 2014 1:28:48 PM

Page 1

Work Order ID: 124976

124976

Parent Item: D4635-1

D4635-1

Parent Item Name: Fwd Ceiling Panel, LH

Start Date: 9/30/2014

Required Date: 10/10/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B
Dwg. Update 12/11/08 DL IPP Rev. C Dwg Update
13/07/09 DL IPP Rev D Dwg Update, Material
Change 13/12/09 DL IPP Rev. E Dwg. Update. 14/01/09 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased		No		100	sf	3,338.313	25.27	26			

MI FXS 093-F6006-07

GE PLASTICS LEXAN SHEET (Grey)

Location

Loc Qty

Loc Code

MAT023

3338.31332

114459

229.26

123105

38

124501

543.5

m128668

181.35

m129014

102.33332

m129471

21.92

m129738

2221.95

DAS

27

9-29

M/10/10

26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

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FAULT CATEGORY

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DART AEROSPACE LTD		Work Order: 124976
Description: LH Fwd Ceiling Panel		Part Number: D4635-1
Inspection Dwg: D4635	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.00	+/-0.030	14.00	✓		TH-C1	
28.00	+/-0.030	28.00	✓		ENC7-09	
42.00	+/-0.030	42.00	✓			
55.00	+/-0.030	55.00	✓			
5.00	+/-0.030	5.00	✓			
12.6	+/-0.100	12.6	✓			
18.6	+/-0.100	18.6	✓			
38.4	+/-0.100	38.4	✓			
44.4	+/-0.100	44.4	✓			
1.3	+/-0.100	1.304	✓			
7.0	+/-0.100	7.0	✓			
7.00	+/-0.030	7.00	✓			
Ø2.03	+0.012/-0.001	2.036	✓			
Ø0.191	+0.005/-0.001	0.1925	✓			
Ø3.50	+0.012/-0.001	3.559	✓			
3.300	+/-0.010	3.297	✓			
1.650	+/-0.010	1.6496	✓			
Ø0.129	+0.005/-0.001	0.1284	✓			
1.300	+/-0.010	1.3006	✓			
0.650	+/-0.010	0.6503	✓			
0.35 - 0.40	+/-0.030	0.397	✓			
0.30	+/-0.030	0.328	✓			
0.50	+/-0.030	0.527	✓			

Measured by: JMS	Audited by:	Preliminary Approval:
Date: 14/11/12	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.29	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

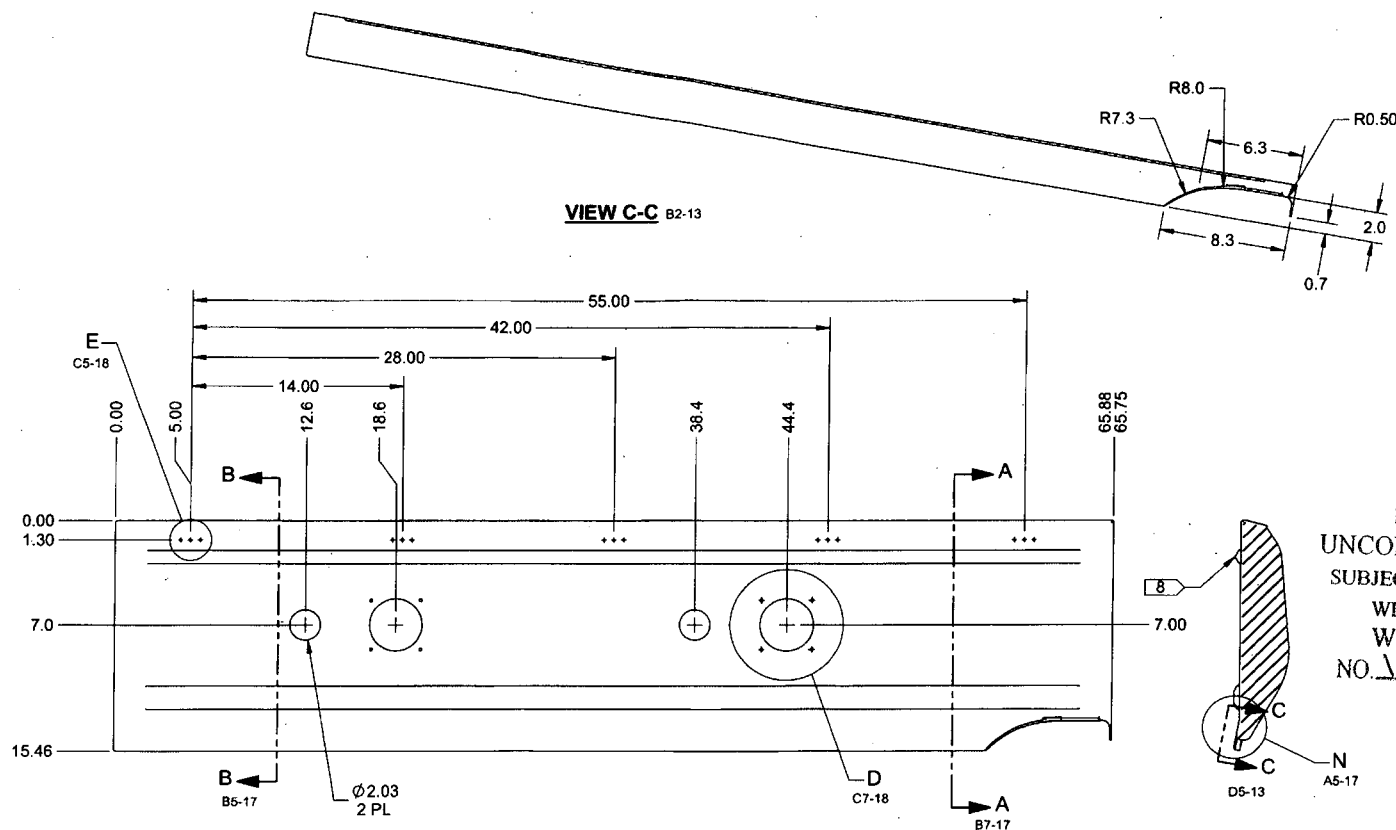
Work Order update only ☐

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 124976 MJS
14-09-30

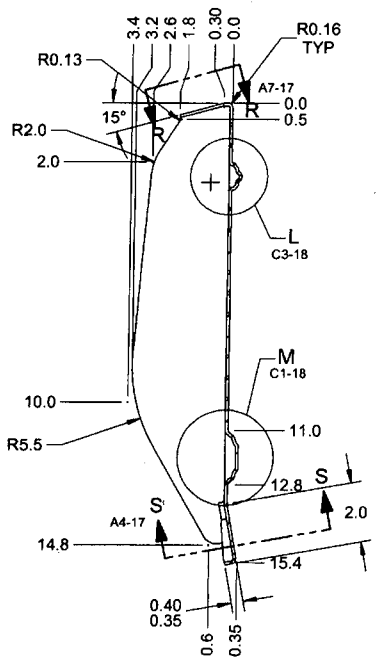
NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.39 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-1 PER TOOL DT9839
- 10) THERMOFORM D4635-1 PER QSI 022 USING DT9847 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.040
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

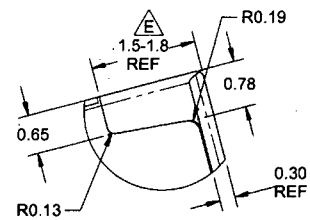
D4635-1 LH, FWD CEILING PANEL

RELEASED
2014-01-22

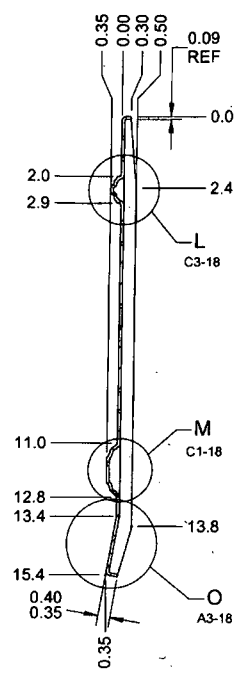
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CHECKED	PC	DRAWING NO. D4635	SHEET 13 OF 18
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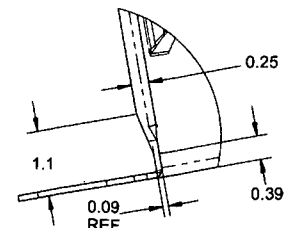
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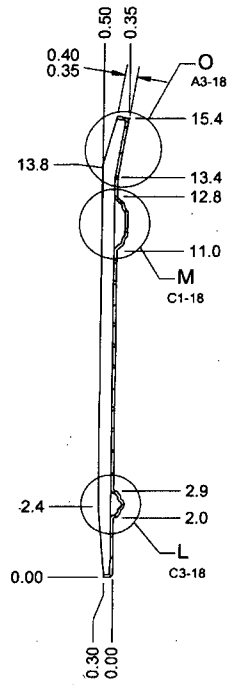
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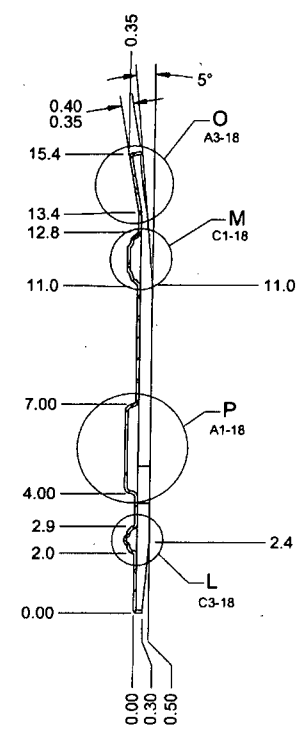
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AUXILIARY VIEW S-S
SECTION S-S' OPPOSITE
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SECTION G-G
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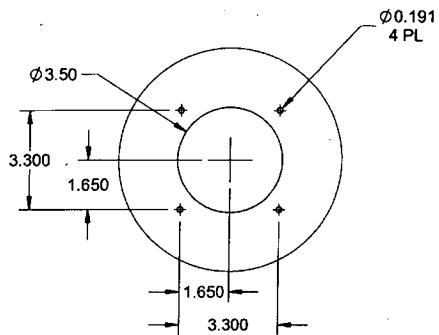


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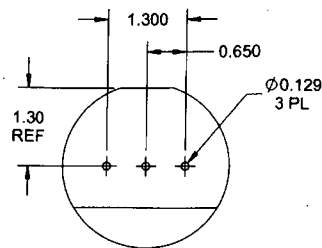
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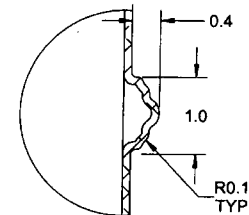
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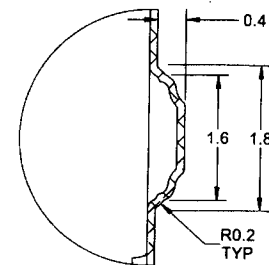
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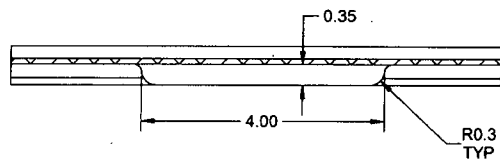
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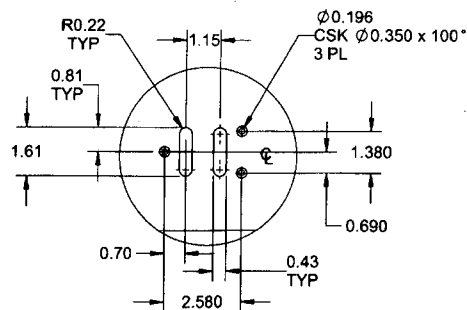
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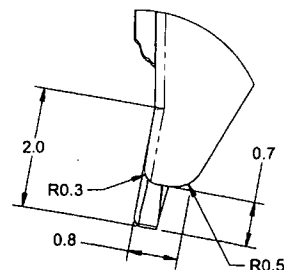
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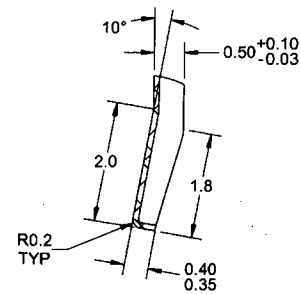
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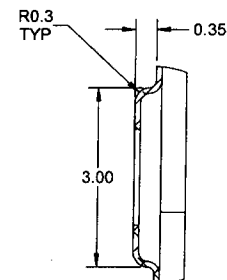
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C5-16



DETAIL N
SCALE 2X
B2-13



DETAIL O
SCALE 2X
D2-17
D3-17
B5-17



DETAIL P
SCALE 4X
C2-17

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8 7 6 5 4 3 2 1